

Reprint

Work Order ID 144740

Tuesday, June 21, 2016 12:42:08 PM

144740

Page 1

Item ID: D3407-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Stem

Start Date: 4/26/2016 Start Qty: 40.00

40

Cust Item ID:

Required Date: 5/10/2016 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3407	Rev E

100

0.00

100

Doosan

Doosan Lathe

DOOSAN LATHE

Memo

6.80

1-Turn as per Folio FA596 Rev: AA & Dwg D3407 Rev: E
Mill slot width at max tolerance .260"

2-Deburr

40 0 DAS 45 9-89 2016-6-21

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.80

40 0 DAS 45 9-89 2016-6-21

120

QC8- Inspect parts - second check

0.00

120

QC

Quality Control

Memo

0.80

40 0 DAS 32 9-89 DAS 44 9-89 16-06-27

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
130									
Packaging	Memo	4.00							
Packaging	LOCATION: WA001								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.40							
Quality Control									

40 JUN 28 2016

DAS
6
9-89

16/6/29 JJ

Lm 16/06/29

Picklist Print

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Page 1

Work Order ID: 144740

144740

Parent Item: D3407-1

D3407-1

Parent Item Name: Stem

Start Date: 4/26/2016

Required Date: 5/10/2016

Start Qty: 40.00

Required Qty: 40.00

Comments:

IPP Rev:A05.10.18New issueKJ/EC

IPP Rev:B Now on Doosan 08-05-14 JLM Verified By:DD

IPP Rev:C 08-08-12 revE as per dwg (ecn 08-507) DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M174R0.750		Purchased		No		100	f	48.4220	0.459	19.32632			

M174R0 750

17-4 round bar .750

Location

Loc Qty

Loc Code

MAT

0.422

m133265

0.422

MAT030

48

m134551

24

m134776

24

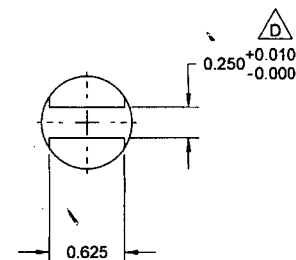
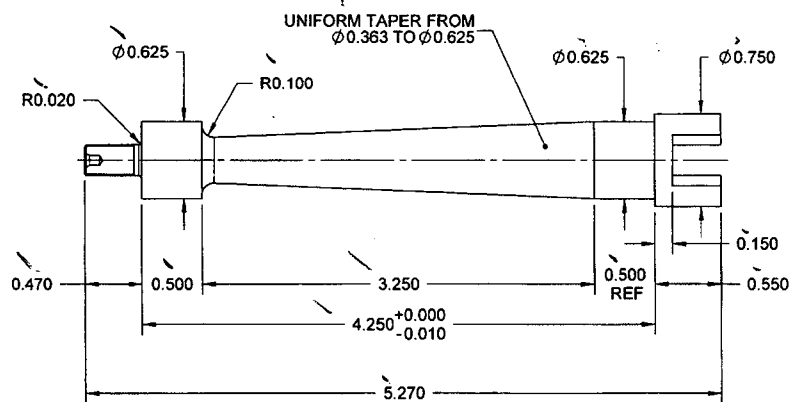
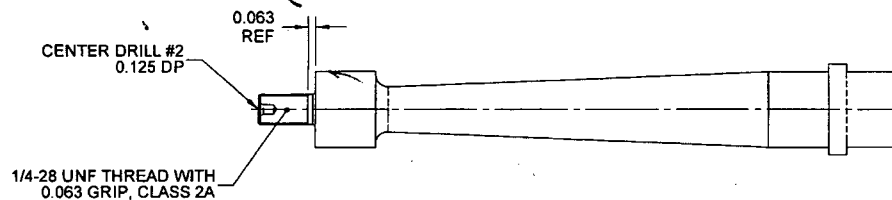
DAS

45

9-89

5#
14#

2016-6-21



D3407-1 STEM

NOTES:

- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.33 lbs

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3407	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		TOW RING	NTS
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